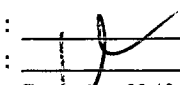
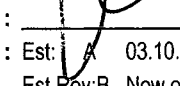


Date: Friday, 11/08/2006 10:39:39 AM
 User: Linda Lacelle











Process Sheet

| | |
|--|-------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : FITTING |
| Job Number : 28146 | |
| Estimate Number : 10870 | |
| P.O. Number : N/A | Part Number : D32163 |
| This Issue : 11/08/2006 S.O. No. : N/A | Drawing Number : D3216 REV A |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A Type : SMALL /MED FAB | Drawing Revision : A |
| Previous Run : 27759 | Material : N/A |
| Written By :  | Due Date : 31/08/2006 |
| Checked & Approved By :  | Qty : 16 Um : Each |
| Comment : Est: A 03.10.28 New Issue KJ/RF Est Rev:B Now on Waterjet 06-07-03 JLM | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---|-----------------------|--|
| 1.0 | M304S11GA | 304/316 .125 Sheet |
|   | | |
| Comment: Qty.: 0.0302 sf(s)/Unit Total : 0.4838 sf(s) 304/316 .125 Sheet (M304S0125) Batch: <u>H101463</u> | | |
| 2.0 | WATER JET | FLOW WATER JET |
|   | | |
| Comment: FLOW WATER JET 1-Cut as per Dwg D3216 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary | | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|   | | |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE | | |
| 4.0 | QC8 | SECOND CHECK |
|   | | |
| Comment: SECOND CHECK | | |
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|   | | |
| Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary. Tumble until parts have a polished finish. <u>Tumble</u> | | |

SAD 06:08:11

2316

SAD 06:08:11

2316

ml 06/08/14

FT 06.08.15

16

16

Date: Friday, 11/08/2006 10:39:39 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 28146

Part Number: D32163

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

June 16 16

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST416*

AP 06/08/16 16

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/08/17 16

Job Completion

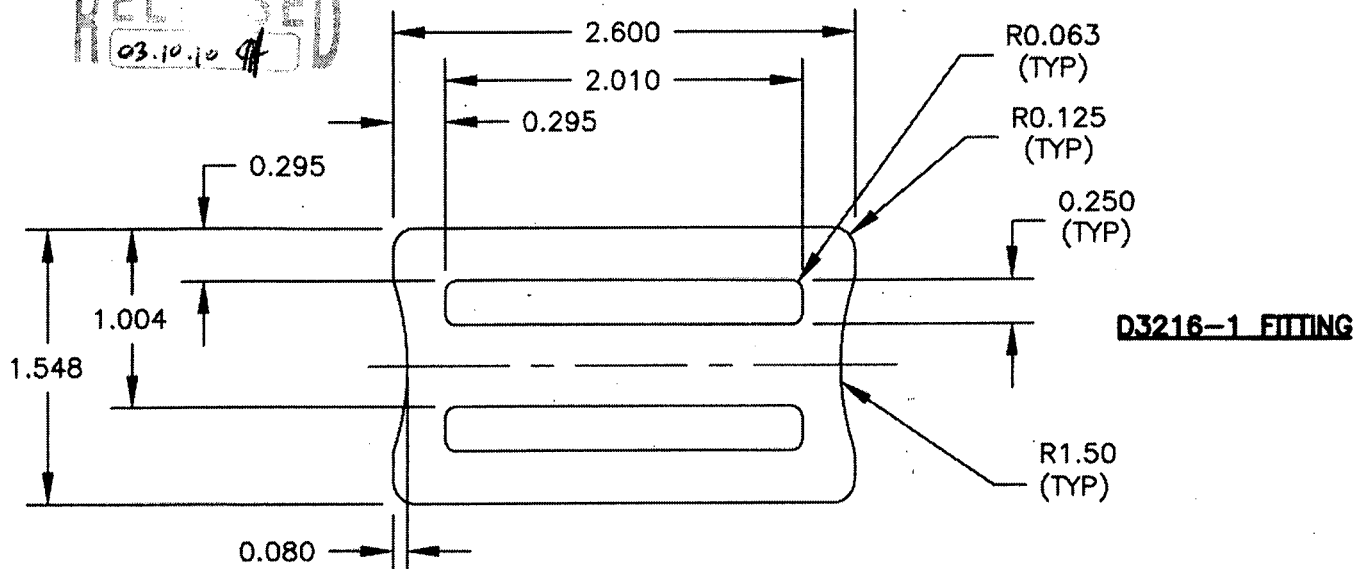
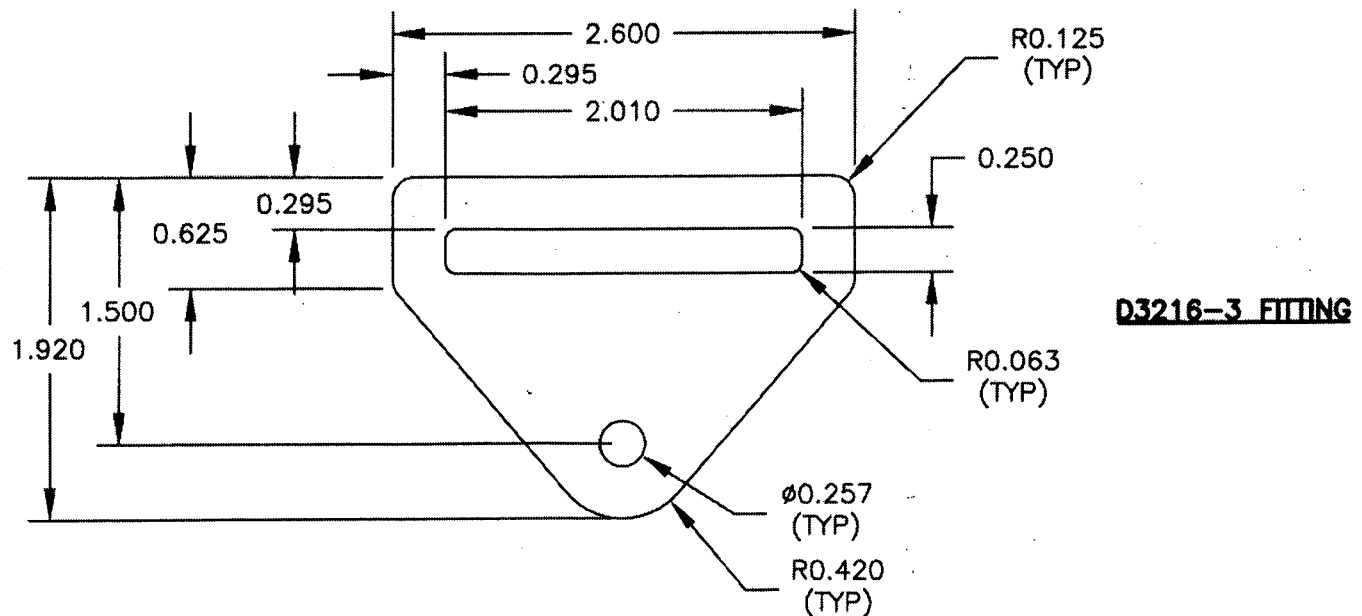


C206108117

DART

| | | | |
|------------------------|-------------------------|---|------------------------|
| DESIGN CP | DRAWN BY CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3216 | REV. A SHEET 1 OF 1 |
| DATE 03.09.26 | | TITLE FITTING | SCALE 1:1 |
| A | 03.09.26 | NEW ISSUE | |

RELEASED
03.10.10

**D3216-1 FITTING****D3216-3 FITTING****D3216-1/-3 FITTING**

- 1) MATERIAL: AISI 304/316 PLATE, 0.125 THICK (REF DART SPEC. M304S11GA)
- 2) FINISH: MOLECRO POLISH
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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| | | |
|--------------------|------|---------------------|
| DART AEROSPACE LTD | | Work Order: 28146 |
| Description: | | Part Number: D32163 |
| Inspection Dwg: | Rev: | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------------------------------|------------------|--------|--------|----------------------|----------|
| 2.600 | ± 0.010 | 2.610 | ✓ | | Vern | |
| 0.295 | ± 0.010 | 0.296 | ✓ | | Vern | |
| 2.010 | ± 0.010 | 2.008 | ✓ | | Vern | |
| 0.295 | ± 0.010 | 0.295 | ✓ | | Vern | |
| 0.625 | ± 0.010 | 0.620 | ✓ | | Vertical Vern | |
| 1.500 | ± 0.010 | 1.496 | ✓ | | Vern | |
| 1.920 | ± 0.010 | 1.920 | ✓ | | Vern | |
| Ø 0.257 | $\pm 0.006 / -0.001$ | 0.260 | ✓ | | Vern Vern | |
| R0.420 | ± 0.010 | R0.420 | ✓ | | R-6 R-6 | |
| R0.063 | ± 0.010 | R0.063 | ✓ | | R-6 R-6 | |
| 0.250 | ± 0.010 | 0.247 | ✓ | | Vern | |
| R0.125 | ± 0.010 | R0.125 | ✓ | | R-6 | |
| 0.125 | ± 0.010 | | | | | |
| 6.125 | ± 0.010 | 6.115 | ✓ | | Vern | |
| | | | | | | |
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|------------------|----------------|-------------------------|
| Measured by: SRO | Audited by: MS | Prototype Approval: N/A |
| Date: 06/08/11 | Date: 06/08/11 | Date: N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |